

Work Order ID 130036

February-23-15 10:38:37 AM

130036

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Item ID: D119-796-151

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)

Start Date: 2/23/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-02-26 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	D								
120	Pick Kit	0.00							DAS
120	Packaging					1			41
Packaging									9-89
Packaging	Memo	0.00							15-8-12
130	Crosstubes	0.00							DAS
130									41
Crosstubes	Memo	0.00							9-89
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-151								15-8-12
	Torque all clamps to 50 IN-LBS max.								
140	QC5- Inspect part completeness to step on W/O	0.00							DAS
140									38
QC	Memo	0.00							AUG 18 2015
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								

POSITIVE RECALL

EFFECTIVE 15.03.26 AUTH A.P.

RELEASED A.P. DATE 15.07.28

SEE OTHER SIDE FOR
DETAILS

DQA:

Date: 15/09/22



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/09/18

Work Order update only ☐

Work Order: 130036	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☒ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Part No. D119-796-151						
NCR No. 15-5336						

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15.07.28	1		CHECK POSITION OF DS152 POST MOUNT ASSY WITH APPROVED JIG-S.	A.P.	USE NEW APPROVED JIG-S			
Doc/Data					15.07.28				
Equip/Tooling		130		CHECK POSITION OF DS149 STEP ASSEMBLY ON FULLY ASSEMBLED GEAR FOR PROPER POSITION. STEP MUST HAVE BEEN MANUFACTURED WITH APPROVED JIG.			DAS 41 9-89 15-8-12	DAS 9 9-89 15-09-09	DAS 9 9-89 15-09-09
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☒ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130036

130036

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Item ID: D119-796-151 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)
 Start Date: 2/23/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							DAS
150	Packaging					1			41
Packaging	Memo	0.00							9-89
Packaging	Identify and pack for shipping as per PPP D119-796-151								15-8-26
									For final assembly
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ AUG 26 2015
 MLJ AUG 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 130036

130036

Parent Item: D119-796-151

D119-796-151

Parent Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1	DAS 41 9-89		
D119-796-141					129978				**	1		15-8-12	
Fwd Crosstube, STD w/o Peg Steps (MKII)													
D5123-3		Manufactured	No				Each	68.0000		4	DAS 41 9-89		
D5123-3					131871				**			15-8-12	
Clamp Cushion													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				lg55				68					
					126747			62					
					127133			6					
D5149-041		Manufactured	No				Each	0.0000		2	DAS 41 9-89		
D5149-041					134500				**	2		15-8-12	
Fwd Step Base Assembly													
MS21920-22		Purchased	No				Each	129.0000		4	DAS 41 9-89		
MS21920-22					132550				**			15-8-12	
Clamp										4			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				LG050				129					
					M128636			54					
					M130822			75					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

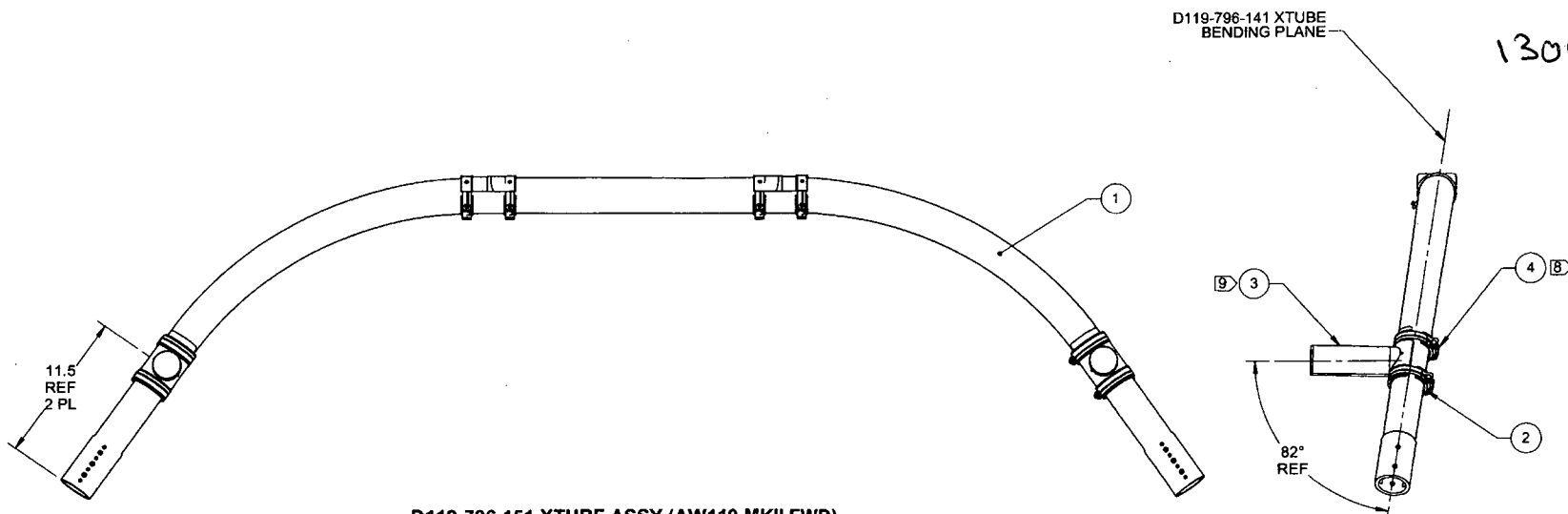
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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FAULT CATEGORY

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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

RELEASED

2015 FEB 09

ECN 15-516

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	DB		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.19		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D119-796-151

REV. D
SHEET 1 OF 1
SCALE
XTUBE ASSY (AW119 MKII FWD) NTS

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